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रबर की मुहरों के लिए पैड — विशिष्टि  
( तीसरा पुनरीक्षण )

**Pads for Rubber Stamps —  
Specification**  
( Third Revision )

ICS 87.080

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July 2023

Price Group 4

## FOREWORD

This Indian Standard (Third Revision) was adopted by the Bureau of Indian Standards after the draft finalized by the Printing Inks, Stationery and Allied Products Sectional Committee had been approved by the Chemical Division Council.

This standard was originally issued in 1968 and revised in 1977 and 1986. In the original standard, the colours of the inked pad were not specified. These were included in the first revision. Changes were also made in the constructional requirements of the base pad.

In IS 393, two grades of ink are prescribed. Grade A is meant for general use and grade B is meant for quick drying. The latter is used for marking ballot papers at the time of elections. As such pads, with ink of grades B cannot pass the performance and keeping quality tests prescribed in this standard. Further, the rubber stamps pads which are sold normally in the market are for general use only and inked with grade A ink of IS 393. In the second revision, only such pads were covered in the Standard. For test purposes the ink conforming to grade A of IS 393 shall only be used.

In this third revision, reference clause and packing and marking clause have been incorporated in the standard.

The composition of the Committee responsible for formulation of this standard is given in Annex B.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***PADS FOR RUBBER STAMPS — SPECIFICATION***( Third Revision )***1 SCOPE**

This standard prescribes the requirements and the methods of sampling and test for fabric stamp-pads for general use with rubber stamps.

**2 REFERENCES**

The Indian Standards listed below contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards.

<i>IS No</i>	<i>Title</i>
IS 187 : 2022	Textiles — Cotton Long Cloth — Specification ( <i>third revision</i> )
IS 393 : 1985	Specification for ink, stamp-Pad ( <i>third revision</i> )
IS 1719 : 2000	Industrial textiles — Pressed wool felts — Specification ( <i>fourth revision</i> )
IS 1848 (Part 1) : 2018	Writing and printing papers — Specification: Part 1 Account book, azure lead, bond, cream laid and cream wove/printing white/printing coloured/printing offset, printing maplitho, printing white super calendered and typewriting types ( <i>fifth revision</i> )
IS 4905 : 2015/ISO 24153 : 2009	Random sampling and randomization procedures ( <i>first revision</i> )

**3 SIZES**

**3.1** The stamp-pads shall be of the following three sizes based on the inner dimensions of the container:

- Large size 16.0 cm × 9.0 cm;
- Medium size 11.0 cm × 7.0 cm; and
- Small size 9.0 cm × 5.0 cm.

**3.1.1** A tolerance  $\pm 0.1$  cm shall be permitted on each dimension.

**4 COLOURS**

**4.1** The stamp-pads may be with or without ink. The inked pads shall have ink (Grade A) as specified in IS 393. It shall be of any of the five colours — violet, blue, green, red and black.

**5 REQUIREMENTS****5.1 Material****5.1.1 Pad**

The pad shall have a non-absorbent base where a base is required to provide support for felt and covering cloth. Otherwise there shall be some suitable fixing arrangement for the cloth covered felt to remain inside the container.

**5.1.1.1 Pad assembly**

The stamp-pad shall have one or two layers of felt, medium hard type, conforming to IS 1719. The total thickness of the felt shall be not less than 3.0 mm. The whole felt shall be covered and securely fixed with a piece of bleached long cloth which shall be free from starch (with 260 ends and 232 picks per dm, and mass 120 g per m<sup>2</sup>; the tolerance on ends, picks and mass shall be  $\pm 5$  percent) (*see* IS 187). A blotting paper shall be placed just under the long cloth for uniform spreading of the ink. The entire pad assembly shall be wrapped in a suitable moisture resistant film like polyethylene, cellulose, of not less than 40 microns if the pad is supplied duly inked.

**5.1.1.2** The pads shall be so constructed that when the stamp is applied to the inked pad evenly, sufficient ink shall be transferred to the face of the type of the stamp to produce a sharp and uniformly clear and legible impression. Pads which do not uniformly ink the face of the type, or pads which allow surplus ink to adhere to the shoulder or sides of the type, shall not be accepted.

**5.1.2 Container**

The pad assembly shall be placed in a suitable plastics or metal container with a hinged lid as agreed to between the purchaser and the supplier. It shall be free from sharp edges, and if made from metal shall not rust.

**5.1.2.1** The pad assembly shall be so held that it rests firmly at the bottom of the container without moving or sliding and shall not touch the inside of the lid.

## 5.2 Performance

The stamp-pad shall conform to the requirements of the test prescribed in 5.2.1.

**5.2.1** Ink the type face of a clean and dry rubber stamp by pressing it firmly on the inked pad. Make an impression immediately upon a sheet of typewriting paper [(see IS1848 (Part 1)]. The pad shall conform to the requirements of the test if the impressions are sharp and uniformly clear and legible, and there is no filling of closed portion of letters or other characters and no impressions other than those determined by the type face. In case of uninked pad, stamp-pad ink conforming to grade A of IS 393 shall be used for testing.

**5.2.1.1** Repeat the operation by inking the rubber stamp and making impressions ten times without further inking the stamp. The tenth impression shall be sharp and distinct.

## 5.3 Keeping Quality

The stamp-pads shall pass the accelerated ageing test prescribed in 5.3.1.

**5.3.1** Keep the inked pad in an oven at  $60\text{ }^{\circ}\text{C} \pm 2\text{ }^{\circ}\text{C}$  for 4 h. Allow to cool to room temperature and take an impression. Repeat the operation of heating and stamping four times. The stamp-pad shall meet the requirements of the test if all the impressions are sharp and distinct.

## 5.4 Resistance to Corrosion (for Metal Containers)

The metal containers shall pass the test for corrosion as prescribed in 5.4.1.

**5.4.1** Suspend the metal containers above water in a desiccator type vessel containing water in place of hygroscopic material, for 48 h at room temperature. The container shall satisfy the requirement of the test if at the conclusion of this

exposure, there is no indication of attack on the protective coating or corrosion of the metal.

## 6 MARKING AND PACKING

### 6.1 Marking

The stamp-pad shall be marked legibly with the following information:

- a) Size of the pad;
- b) Colour of pad, if inked;
- c) Manufacturer's name and/or recognized trade-mark, if any; and
- d) Batch number in code or otherwise to enable the lot of manufacture to be traced from records.

#### 6.1.1 BIS Certification Marking

The brushes may also be marked with the Standard Mark.

**6.1.1.1** The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed there under, and the products may be marked with the Standard Mark.

### 6.2 Packing

The stamp-pads shall be packed as agreed to between the purchaser and the supplier.

## 7 SAMPLING

**7.1** The method of drawing representative samples of the material from a lot, number of tests to be performed and the method of finding out the criteria of conformity of the material to the requirements of this specification shall be as prescribed in Annex A.

## ANNEX A

(Clause 7.1)

## SAMPLING OF STAMP-PADS FOR RUBBER STAMP

## A-1 SCALE OF SAMPLING

## A-1.1 Lot

In a single consignment all the stamp-pads of the same size and colour belonging to the same batch of manufacture shall constitute a lot.

**A-1.2** For ascertaining conformity to the requirements of this specification, each lot shall be considered separately.

**A-1.3** The number of samples to be selected for inspection from each lot shall be in accordance with col 1 and 2 of Table 1.

**A-1.4** The samples shall be withdrawn at random from the lot. For random selection procedures, guidance can be had from IS 4905. In case random number tables are not available, the following procedure may be adopted:

Starting from any stamp-pad, count all the stamp-

pads in the lot in one order as 1, 2, 3, . . . . .) etc, up to  $r$  and so on where  $r$  is the integral part of  $N/n$  (see Table 1 for  $N$  and  $n$ ). Every  $r$ th pad thus counted shall be withdrawn to constitute the sample.

## A-2 NUMBER OF TESTS AND CRITERIA FOR CONFORMITY

**A-2.1** All the stamp-pads in the sample selected according to A-1.3 and A-1.4 shall be inspected for all the requirements of the specification. Any stamp-pad in the sample failing to meet one or more of the requirements shall be considered as defective.

**A-2.2** The lot shall be declared conforming to the requirements of this specification if the number of defective stamp-pads in the sample does not exceed the corresponding permissible number (a) given in col (3) of Table 1.

Table 1 Scale of Sampling

(Clause A-2.2)

SI No.	Number of Pads in the Lot	Number of Pads in the Sample	Permissible Number of Defective Pads
	$N$	$n$	$a$
(1)	(2)	(3)	(4)
i)	Up to 50	2	0
ii)	51 to 150	5	1
iii)	151 to 350	8	2
iv)	301 to 500	13	3
v)	501 to 1 000	20	5
vi)	1 001 and above	32	7

**ANNEX B***(Foreword)***COMMITTEE COMPOSITION**

Printing Inks, Stationery and Allied Products Sectional Committee, CHD 14

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Govt Printing, Govt of West Bengal	SHRI SUBIR KUMAR MANDAL ( <i>Chairperson</i> )
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SHRI SAGAR SINGH  
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This Indian Standard has been developed from Doc No.: CHD 14 (20164).

### Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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